

# Work Order ID 52825

October 15, 2009 10:38:11 AM



Page 1

Item ID: D2989-041  
Revision ID: D  
Item Name: Basket Lid Assembly

Accept



Setup Start



Stop



Start Date: 15/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 29/10/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: RA Date: 09/10/15 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2989	Rev D

100 0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- assemble all ribs and both D2581 in DT9445 jig, weld as per dwg D2989

2- tack weld mesh on basket as per dwg D2989 using DT9445 jig

\*\*\*\*cut cutouts with zip cut as per dwg D3832\*\*\*\*

3- remove from jig and weld lable plate as per dwg D2989

A/R ER316 S.S. Rod Batch: M109213

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

09/10/26 (1x)

QC 09 10 26

**Abstract**

October 15, 2009 10:38:11 AM

**Accept**

\_\_\_\_\_

**Setup Start**

[REDACTED]

**Stop**

1 1111111111 1111111111 1111111111 1111111111

**Abstract**

**Cust Item ID:**

**Customer:**

**Reference:**

Run Start

\_\_\_\_\_

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

**Stop**

**RESEARCH DESIGN**

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

### Operation Description

### Set Up/ Run Hours

**Draw  
Number**

**Draw**  
**Rev.**

### Plan Code

**Accept  
Qty**

Reject  
QtyReject  
Number

**Insp.  
Stamp**

120

QC5- Inspect part completeness to step on W/O

0.00

[illegible]

QC

## Memo

0.00

2) 50/10/22

## Quality Control

—

# Work Order ID 52825


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Page 3

Item ID:	D2989-041	Accept		Setup	Start	
Revision ID:	D				Stop	
Item Name:	Basket Lid Assembly					
Start Date:	15/10/2009	Start Qty:	1.00	Cust Item ID:		
Required Date:	25/10/2009	Req'd Qty:	1.00	Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel <i>PRESSURE WASH</i> Memo 1- Plug holes prior to powder coating  2-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989  3-Wing walk D2989-041 as per Dwg D2989 and QSI 005 4.4 Spray Paint Black: <input type="checkbox"/> Wing Walk: <input type="checkbox"/>  1ST COAT: START TIME: <i>1:45pm</i> OVEN TEMPERATURE: <i>400°</i> FINISH TIME: <i>2:15pm</i> ***** 2nd coat if necessary*****  2ND COAT: START TIME: <i>2:45pm</i> OVEN TEMPERATURE: <i>400°</i> FINISH TIME: <i>3:15pm</i>	0.00 <i>0.00</i>	<i>09-10-27</i> <i>21</i>	<i>1</i> <i>09/10/27</i>		<i>(21)</i>	<i>0</i>		

*10/10/28*

# Work Order ID 52825

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Page 4

Item ID:	D2989-041	Accept		Setup	Start	
Revision ID:	D				Stop	
Item Name:	Basket Lid Assembly					
Start Date:	15/10/2009	Start Qty: 1.00		Cust Item ID:		
Required Date:	29/10/2009	Req'd Qty: 1.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
131  HandFinish Hand Finishing	Wing Walk as per dwg QST005 4.4 Batch Spray paint Black per dwg Batch: <u>M112/06</u> Memo	0.00 0.00	<u>M112/06</u>	<u>08-10-08</u>		①			
140  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00		<u>27 8-8/10/09</u>		⑩			
141  Packaging Packaging	Identify as per dwg & Stock Location: Memo	0.00 0.00		<u>PPP</u> <u>82 8/9</u>		<u>129/10/09</u>			

**Work Order ID 52825**

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Item ID: D2989-041

Accept



Setup Start



Revision ID: D

Stop



Item Name: Basket Lid Assembly

Start Date: 15/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 29/10/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

09/10/30

MF  
09-10-29

# Picklist Print

October 15, 2009 10:38:21 AM

Page 1

Work Order ID: 52825

Parent Item: D2989-041RevD

Parent Item Name: Basket Lid Assembly

Start Date: 15/10/2009

Required Date: 29/10/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2221-1RevH

Manufactured

No

100

Each

17.0000

2.0000



Rib

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1

48101

1

Main Warehouse

WA

16

51250

4

51872

12

2x 09/10/22

D2506RevF

Manufactured

No

100

Each

6.0000

1.0000



Label Plate

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

2

44275

1

51135

1

Main Warehouse

WA

4

51303

4

1x 09/10/22

# Picklist Print

Page 2

October 15, 2009 10:38:21 AM

Work Order ID: 52825

Parent Item: D2989-041RevD

Parent Item Name: Basket Lid Assembly

Start Date: 15/10/2009

Required Date: 29/10/2009

Start Qty: 1.00

Required Qty: 1.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2512-7RevE		Manufactured	No			100	Each	5.0000	1.0000			

Rib

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	5	
43987	1	
48666	4	

1x *dy* 09/10/22

D2581RevA1

Manufactured No



Mounting Bracket

100

Each

76.0000

2.0000

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	13	
46086	2	
48428	1	
51120	10	
Main Warehouse		
WA	63	
50872	14	
51745	49	

2x *dy* 09/10/22

# Picklist Print

October 15, 2009 10:38:21 AM

Work Order ID: 52825

Parent Item: D2989-041RevD

Parent Item Name: Basket Lid Assembly

Start Date: 15/10/2009

Required Date: 29/10/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2989-13RevD		Manufactured	No			100	Each	6.0000	2.0000			

Rib

✓

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	2	
50579	2	
Main Warehouse		
WA	4	
51864	4	

2x 09/10/22

D2989-19RevD

Manufactured No

100

Each

11.0000

2.0000



Rib

✓

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	3	
44867	1	
48102	2	
Main Warehouse		
WA	8	
51338	4	
51874	4	

2x 09/10/22



# Picklist Print

Page 4

October 15, 2009 10:38:21 AM

Work Order ID: 52825



Parent Item: D2989-041RevD



Parent Item Name: Basket Lid Assembly

Start Date: 15/10/2009

Required Date: 29/10/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3832-3RevA		Manufactured	No			100	Each	5.0000	1.0000			



Mesh (Lid)

✓

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	5	
48608	2	
51865	3	

1x *SY* 09/10/22

D3833-3RevA

Manufactured No

100

Each

5.0000

2.0000



Mesh (Lid End)

✓

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	5	
46308	5	

2x *SY* 09/10/22

# Picklist Print

October 15, 2009 10:38:21 AM

Work Order ID: 52825



Parent Item: D2989-041RevD



Parent Item Name: Basket Lid Assembly

Start Date: 15/10/2009

Required Date: 29/10/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3836-041RevA		Manufactured	No			100	Each	3.0000	1.0000			

Rib Assembly (Basket Lid, LH)

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	2	
51336	2	
Main Warehouse		
WA	1	
50578	1	

1x 24 09/10/22

D3836-042RevA

Manufactured No



Rib Assembly (Basket Lid, RH)

100	Each	3.0000	1.0000

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	2	
51337	2	
Main Warehouse		
WA	1	
50577	1	

1x 24 09/10/22

# Picklist Print

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Work Order ID: 52825

Parent Item: D2989-041RevD

Parent Item Name: Basket Lid Assembly

Start Date: 15/10/2009

Required Date: 29/10/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3852-041RevA		Manufactured	No			100	Each	3.0000	1.0000			

Rib Assembly

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

3

50581

1

51333

2

100

Each

3.0000

1.0000

1x 09/10/22

D3852-042RevA

Manufactured

No



Rib Assembly

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

3

50581

1

51332

2

1x 09/10/22

**D2989-043 BASKET LID ASSEMBLY**  
(MESH SHOWN LOCALLY FOR CLARITY)

**D2989-041 BASKET LID ASSEMBLY**  
(MESH SHOWN LOCALLY FOR CLARITY)

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
1	X		D2989-041	BASKET LID ASSEMBLY
2		X	D2989-043	BASKET LID ASSEMBLY
3	1		D2506	LABEL PLATE
4	1		D2512-7	RIB
5	2		D2581	MOUNTING BRACKET
6		1	D2989-3	RIB
7		1	D2989-4	RIB
8		2	D2989-5	RIB
9	2		D2989-13	RIB
10	2	1	D2989-17	RIB
11	2		D2989-19	RIB
12		2	D3182-1	HINGE
13		2	D3442-3	SHIM
14		1	D3827-041	RIB ASSY (INBOARD)
15	1		D3832-3	MESH, BASKET LID
16		1	D3832-5	MESH, BASKET LID
17	2		D3833-3	MESH, LID END
18		2	D3833-5	MESH, LID END
19	1		D3836-041	RIB ASSY (BASKET LID, LH)
20	1		D3836-042	RIB ASSY (BASKET LID, RH)
21		1	D3838-041	RIB ASSY (BASKET LID, LH)
22		1	D3838-042	RIB ASSY (BASKET LID, RH)
23	1		D3852-041	RIB ASSEMBLY
24	1		D3852-042	RIB ASSEMBLY

RELEASED  
08/11/18

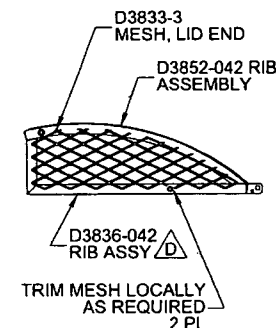
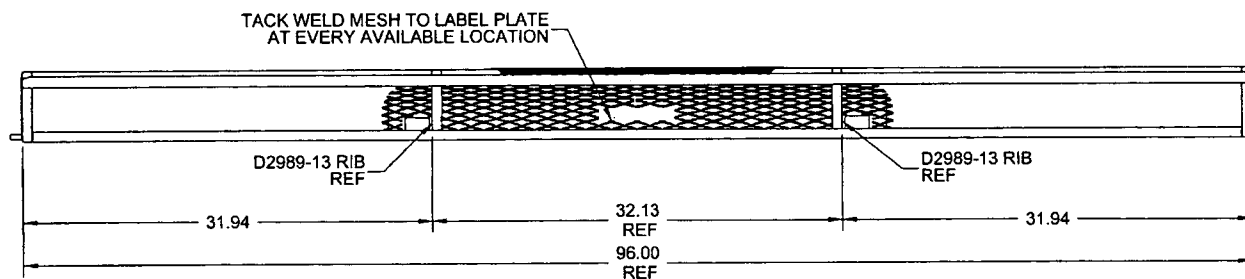
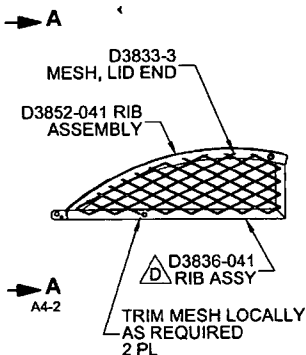
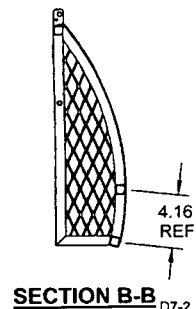
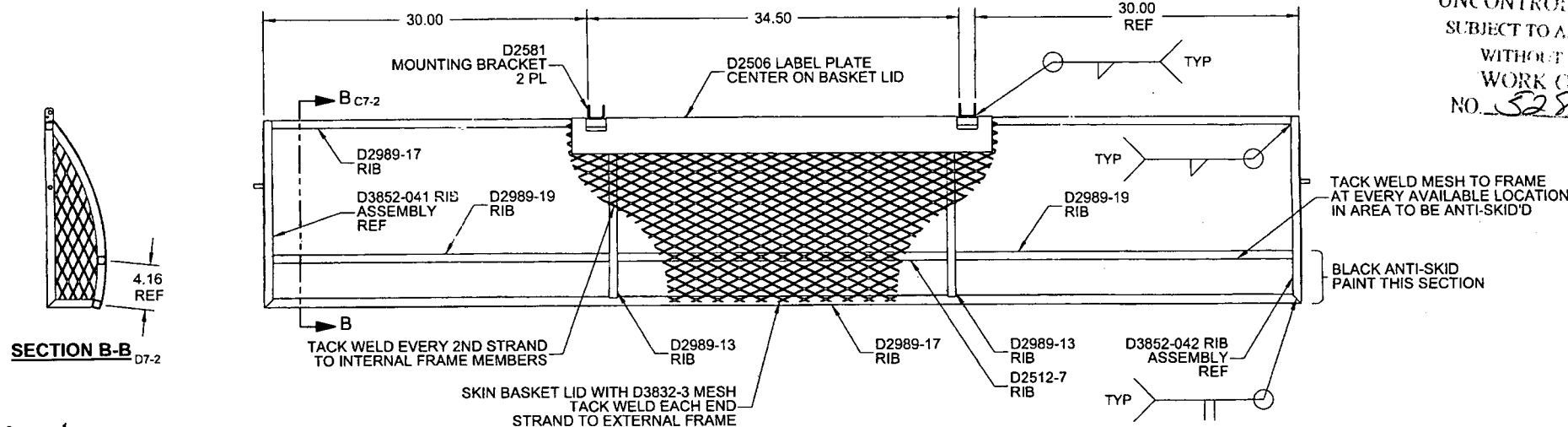
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FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4  
SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID  
TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
UNITS: INCHES UNLESS OTHERWISE NOTED  
BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
IDENTIFICATION: N/A  
WEIGHT: D2989-041 = 26.50 lbs; D2989-043 = 15.50 lbs  
WELD PER DART QSI 004

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WORK ORDER  
NO. 52825  
BL 09-10-15

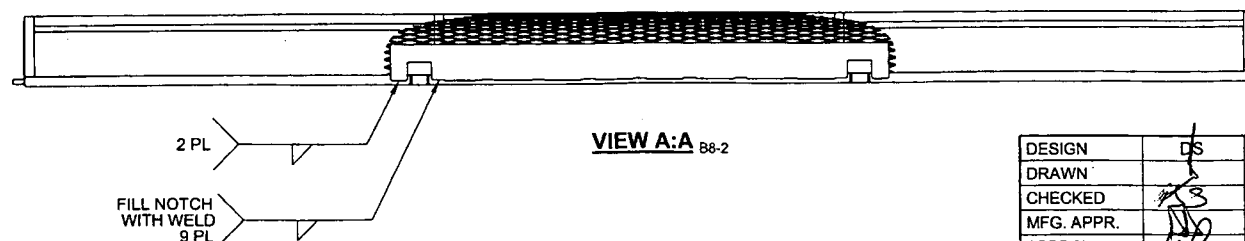
D	REVISED -041/-043 PARTS LISTS AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); D3836-041 REPLACES D2989-9/-15; D3836-042 REPLACES D2989-10/-15; D3838-041 REPLACES D2989-11/-7; D3838-042 REPLACES D2989-2/-7; D3852-041 REPLACES D2989-11; D3852-042 REPLACES D2989-2. REMOVED D2327-3 (NOW INSTALLED ON D3838 DWG), D2989-9/-10 (NOW ON D3836 DWG), D2989-1/-2/-7/-15 (NOW ON D3838 DWG) AND D2989-11/-12 (NOW ON D3852 DWG). REASON: TO SATISFY "LEAN MANUFACTURING" PROGRAM	MB	08.09.24
C	FRAME MATERIAL WAS 0.060 WALL; MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT AND CURRENT DRAFTING STANDARD	AJS	08.06.20
B	ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS	PH	05.06.07
A	NEW ISSUE	DS	00.10.27
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	AJS	DRAWING NO.	REV. D
MFG. APPR.		D2989	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
DATE	08.09.24	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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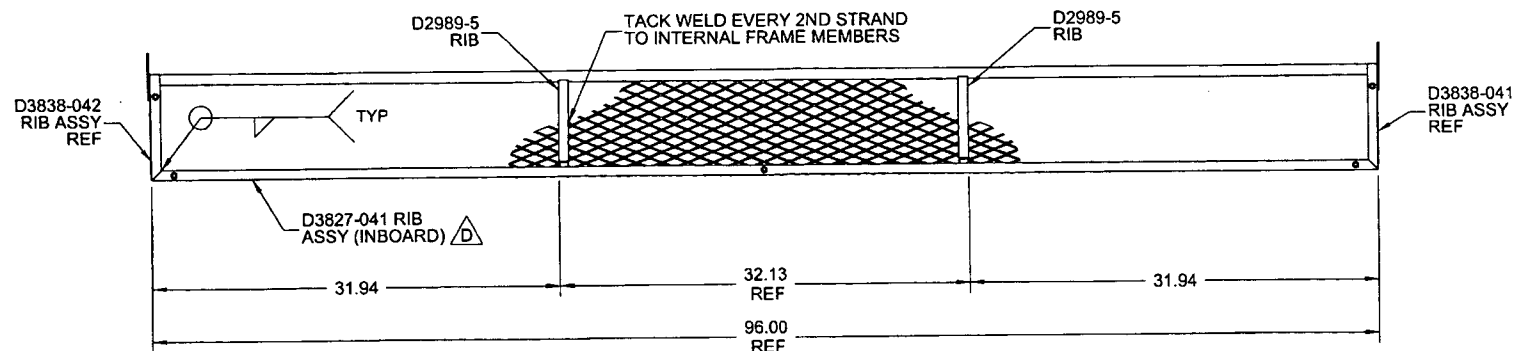
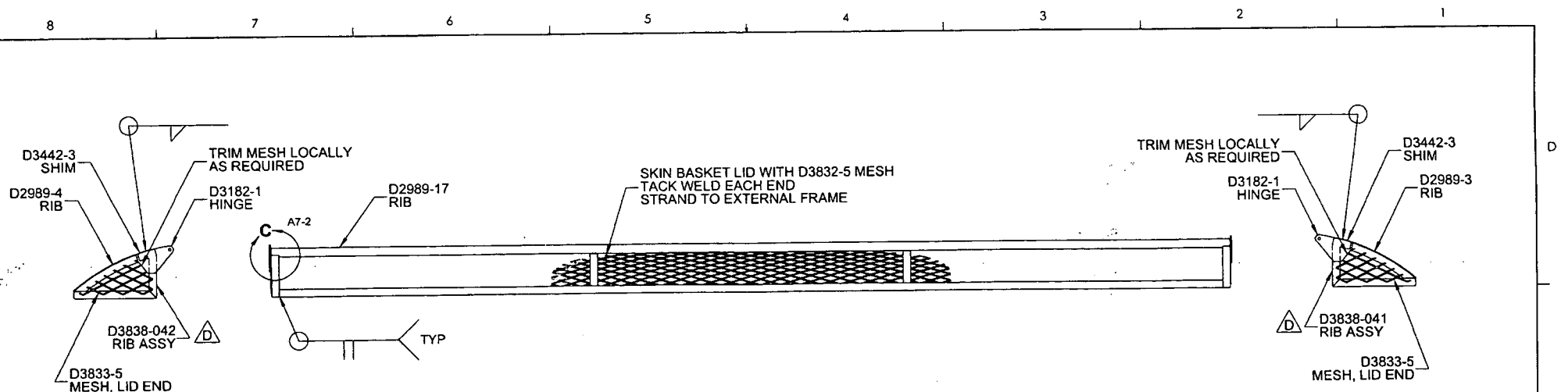
**D2989-041 BASKET LID ASSEMBLY**  
(MESH SHOWN LOCALLY FOR CLARITY)



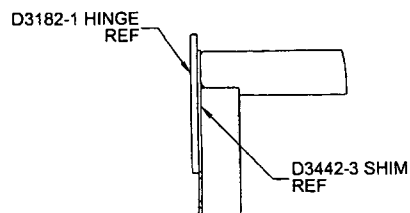
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08/11/18

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DRAWN	KS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KS	DRAWING NO. D2989	REV. D
MFG. APPR.	KS	SHEET 2 OF 5	
APPROVED	KS	TITLE	SCALE
DE APPR.	KS	BASKET LID ASSEMBLY	
DATE	08.09.24	NTS	

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**D2989-043 BASKET LID ASSEMBLY**  
(MESH SHOWN LOCALLY FOR CLARITY)



**DETAIL C**  
TYP, SCALE 4X

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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	MS	DRAWING NO. D2989	REV. D
MFG. APPR.			SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		<b>BASKET LID ASSEMBLY</b>	NTS
DATE	08.09.24	<small>COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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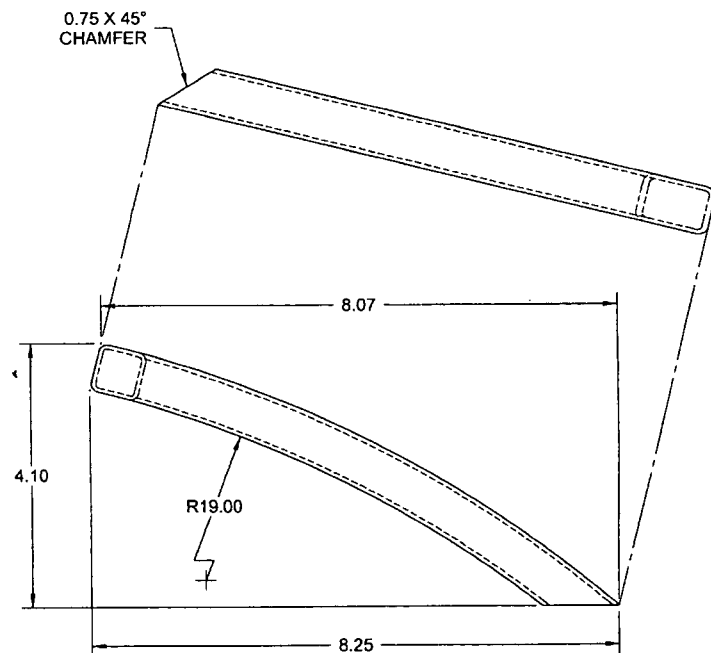
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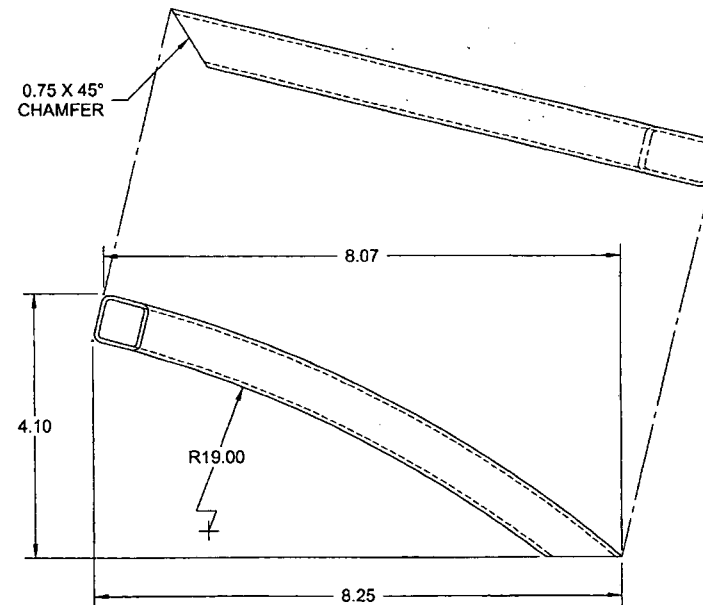
WITHOUT NOTICE

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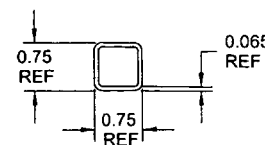
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**D2989-3 RIB**



**D2989-4 RIB**

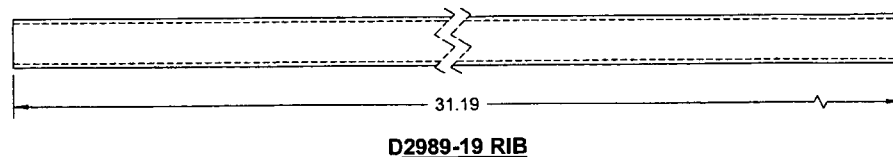
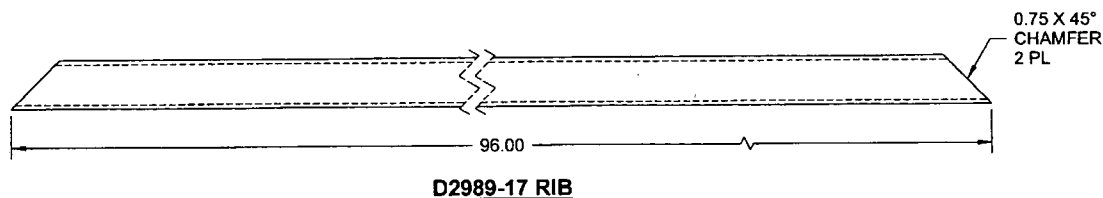
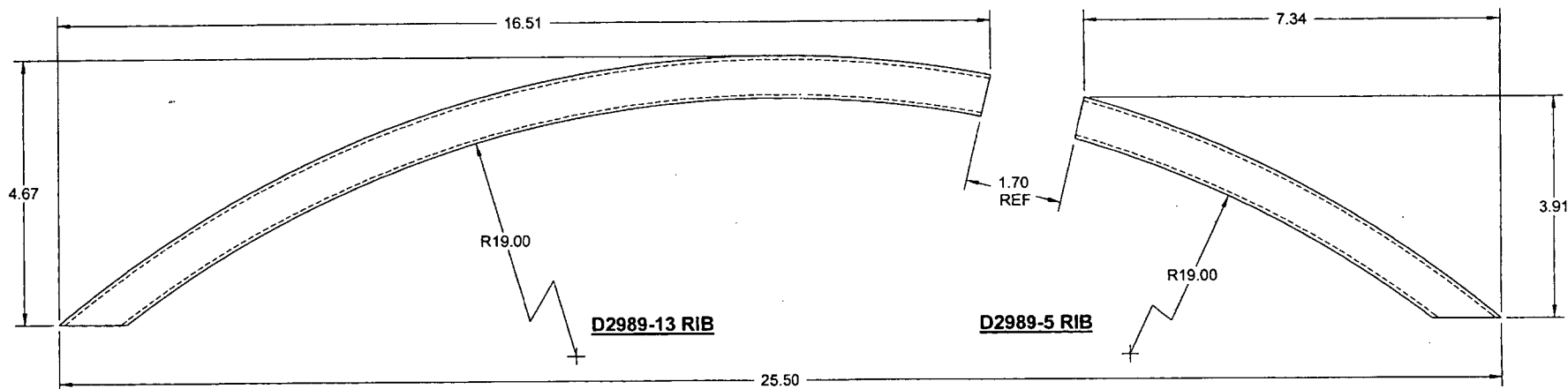


**TYPICAL SECTION  
VIEW**

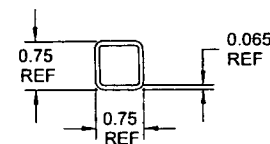
- NOTES:
- MATERIAL: D3166-3 BASKET HOOP
  - FINISH: NONE
  - TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - UNITS: INCHES UNLESS OTHERWISE NOTED
  - BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - IDENTIFICATION: N/A
  - WEIGHT: D2989-3/-4 = 0.39 lbs;

**RELEASED**  
08/11/18/11

DESIGN	DS	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>D2989</b>	REV. D
MFG. APPR.			SHEET 4 OF 5
APPROVED		TITLE <b>BASKET LID ASSEMBLY</b>	SCALE NTS
DE APPR.		DATE <b>08.09.24</b>	
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**TYPICAL SECTION  
VIEW**

**RELEASED**  
08/11/18

- NOTES:**
- MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL  
REF. DART SPEC. M304TS0.750W0.065
  - FINISH: NONE
  - TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - UNITS: INCHES UNLESS OTHERWISE NOTED
  - BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - IDENTIFICATION: N/A
  - WEIGHT: D2989-5 = 0.37 lbs; D2989-13 = 0.81 lbs; D2989-17 = 4.57 lbs; D2989-19 = 1.50 lbs

DESIGN	DS	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	DS	DRAWING NO. <b>D2989</b>	REV. D
MFG. APPR.			SHEET 5 OF 5
APPROVED	NTS	TITLE <b>BASKET LID ASSEMBLY</b>	SCALE
DE APPR.			NTS
DATE	08.09.24	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	